



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2873-043
Job Sheet 195397



Part No: D2873-043

Job Qty: 40 pcs

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/21/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	40 pcs	6/14/19	6/14/19	0.00	0.19	Bandsaw - 1		VHS 19/6/3
110	HAAS 4 Axis - B4B	40 pcs	6/14/19	6/14/19	0.04	10.55	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		VHS 19/6/3
							HAAS - 4 - B4B		
120	QC 2	40 pcs	6/14/19	6/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		VHS 19/6/3
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S186472



Part: D2873 - 043

Job No: 195397

Serial No/Batch: S186472

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

Date: 06/03/19

130	QC 8	40 pcs	6/14/19	0.00	0.00	QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	19-06-03
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
150	QC 5	40 pcs	6/14/19	0.00	0.00	QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
							JUN 03 2019
							DAS 40 9-89
160	Handfinish - 1-1 Chemical-B4B	40 pcs	6/14/19	0.00	0.50	Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	JUN 06 2019
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	

						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
170	QC 7	40 pcs	6/14/19	0.00	0.00	QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
180	Small Fab - 2 - B4B	40 pcs	6/14/19	0.00	1.36	Small Fab - 1 - B4B	
						Small Fab - 2 - B4B	

DAS
40
9-89

JUN 06 2019

190 QC 5	40 pcs	6/14/19	0.00 0.00	Small Fab - 3 - B4B	JUN 07 2019
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
200 Packaging 3-1 - Stock - B4B	40 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B	JUN 10 2019
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	JUN 10 2019
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	JUN 10 2019
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	

Plex 5/21/19 1:33 PM Dart.lajeunesse.marie

					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	40 pcs	6/14/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21 JUN 10 2019
					QC 21 - SA - 53	9-55

Part Op **100** - Cut blanks: 1.000" x 0.375" x 3.700" longDescriptions: **110** - (HAAS CNC Vertical Machine) Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev A Folio Rev AA**120** - (QC2- Inspect parts off machine FAI/FAIB)**130** - (QC8- Inspect parts - second check)**150** - (QC5- Inspect part completeness to step on W/O)**160** - (Chemical Conversion Coat per QSI005 4.1)**170** - (QC7-Inspect Chemical Conversion Coat)**180** - 1-Assemble as per Dwg D2873 2-Identify as D2873-043**190** - (QC5- Inspect part completeness to step on W/O)**200** - (Identify as per dwg & Stock Location: _____) LOCATION : LG050**210** - (QC21- Final Inspection - Work Order Release)**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	12.3320 ft (.3083 ea)	100-Bandsaw - 1	5 Q506024 x 19.23 po
MS20426AD4-6	Rivet	240 Ea (6 ea)	180-Small Fab - 2 - B4B	8185056
MS21075L5	Nut Plate	120 Ea (3 ea)	180-Small Fab - 2 - B4B	628 160317-582185066

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.375X1.000	12	6	0
180-Small Fab - 2 - B4B	MS20426AD4-6	240	1,397	0
	MS21075L5	120	299	0

Part Specifications

Specifications could not be found.

Plex 6/7/19 9:14 AM dart.boucher.sylvie

DART AEROSPACE LTD		Work Order:	195357
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.501	✓		Vernier	HJ-01
2.000	+/-0.010	2.000	✓			
0.750	+/-0.010	0.750	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	0.252	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	✓			
3.000	+/-0.010	3.000	✓			
Ø0.128	+0.005/-0.001	0.128	✓		Gage Pin	
0.359	+/-0.010	0.359	✓		" "	" "
Ø0.316	+0.006/-0.001	0.316	✓		Gage Pin	
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	0.252	✓			
0.061	+/-0.010	0.061	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.230 x 126	✓			

Measured by:	VH8	Audited by:	DAS 20 9-89	Prototype Approval:	N/A
Date:	19/11/2	Date:	19-06-03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					